

Date: Monday, 16/03/2009 9:18:00 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Job Number : 46503	
Estimate Number : 12472	
P.O. Number :	Part Number : D135751011
This Issue : 16/03/2009 S.O. No. :	Drawing Number : D3507 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : C
Previous Run : 46502	Material :
Written By :	Due Date : 31/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : : Est Rev:A 06-06-21 New Issue JLM : Est Rev:B 06-12-18 As per Rev B JLM : Est Rev:C 07-12-11 ECN 1036 as per revB DD : Est Rev D 08.11.04 Added DT9431 to sequence 5 EC : vcerified DD	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



HJ for JLD 09/04/09



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

S 09/04/09

2.0

D2962150

3.540 Outer Tube, Extrut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion

B28672

RD

9-3-16

3.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

MD

09-07-16

①

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per program

on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

MS

09-03-16

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16" drill. ****DO NOT OPEN AFT CAP HOLES*****

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open holes section C-C to .375" and locate DT9431 using "T" pin & cleco.

10- Drill holes section G-G (DT9431)

11-Open Aft & Fwd Cap holes using .208" drill.

12-Bore out aft end of tube as per Dwg D3507 & Detail "B".

13-Open ground wire hole .297" section E-E

14-Deburr holes.

9-3-16

9-3-17

9-3-17

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5096317

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PM 503-17

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JP 9-3-17

9.0

D35043

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSBOLT SPACER

Batch:

B31232

BE 09-03-19

10.0

D35041

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CROSSBOLT SPACER

Batch:

B31234

BE 09-03-19

11.0

D35051

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Batch:

B46541

pm 09-03-18 (1)

12.0

D35061

Doubler



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

Batch:

B28369 B28963 B41605x3 B46538x1

13.0

D35063

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

DOUBLER

Batch:

B46539

pm 09-03-19

14.0

D35045

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CROSSBOLT SPACER

batch:

B36181 BE 09-03-19

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch:

M107823

PM 09-03-19

12

15

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch:

M109883

Exp Date: 09-07-11

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch:

M10923

BE 09-03-19

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

PM 09-03-18

PM 09-03-19

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 09-03-19

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

PM 09-03-19

W/O:		WORK ORDER CHANGES						
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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/23 (X)

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

HL

09-04-02

(X)

21.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

110939

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

BR

09-04-02

(X)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-07

(X)

23.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M 108606

HL

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: M 19393

HL

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

HL

09-04-07

(X)

W/O:		WORK ORDER CHANGES						
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Job Number: 46503

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

Soldered

27.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch M 108062

HI *

28.0

D29653

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 46582

HI

29.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 41523

HI

30.0

D35081

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 412973

HI

31.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 42250

HI

32.0

D35085

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B 42251

HI

09-04-07

(K)

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46503

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D35087

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1344518

Handwritten initials

34.0

D35581

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342533

Handwritten initials

35.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1345661

Handwritten initials

36.0

D35585

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343244

Handwritten initials

37.0

D35587

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1343245

Handwritten initials

38.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M110715

Handwritten initials

39.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: M106513

Handwritten initials

09-04-07

Handwritten initials

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 46503

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

NAS1611007

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

batch: _____

MA W

41.0

D3492041

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

Batch: *B43816*

HL

42.0

D3492043

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

batch: *(3x) B45339 / (1x) 46407*

HL

43.0

D3492047

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

Batch: *B28961*

HL

44.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total : 33.0000 Each(s)

Washer

Batch: *M110916*

HL

45.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)

BOLT

Batch: *M111279*

HL

46.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M110916*

HL 09-04-07 (XU)

W/O:		WORK ORDER CHANGES						
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Job Number: 46503

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

✓ A/R 241 Sika Flex Batch: M109883

Exp Date: 09-11

3-Install Wearplates as per Dwg D3507 ,

✓ Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: M110983

Exp Date: 09/11

✓ 4-Install Plug assemblys as per Dwg D3507.

→ Batch: M11013

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

— FL

09/04/07

(1)

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/08 (x)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D35121

Wearplate



5 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: 44642

88 09/04/09 (x)

51.0

AN960JD10L

Washer



5 Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M109632

88 09/04/09 (x)

W/O:		WORK ORDER CHANGES						
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Job Number: 46503

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

BATCH:

M111193

28.9/04/09

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5.0/04/09

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev:

82

B

9/4/9

59

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



6.09.04.09

46503

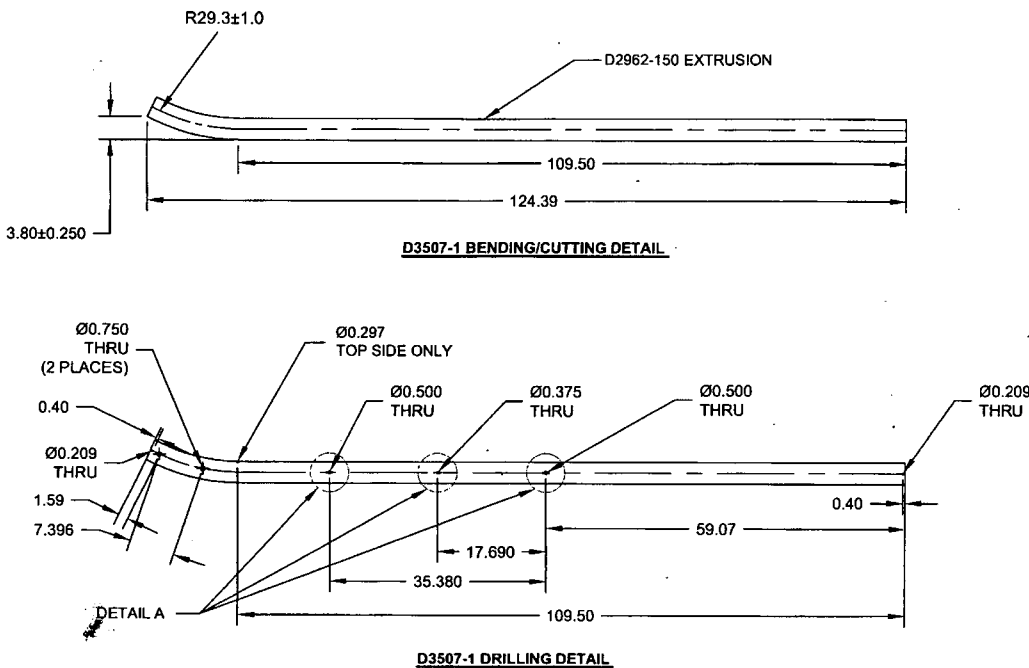
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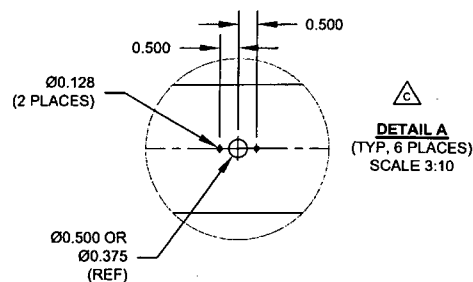


Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1*	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
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WORK ORDER
NO. 110003

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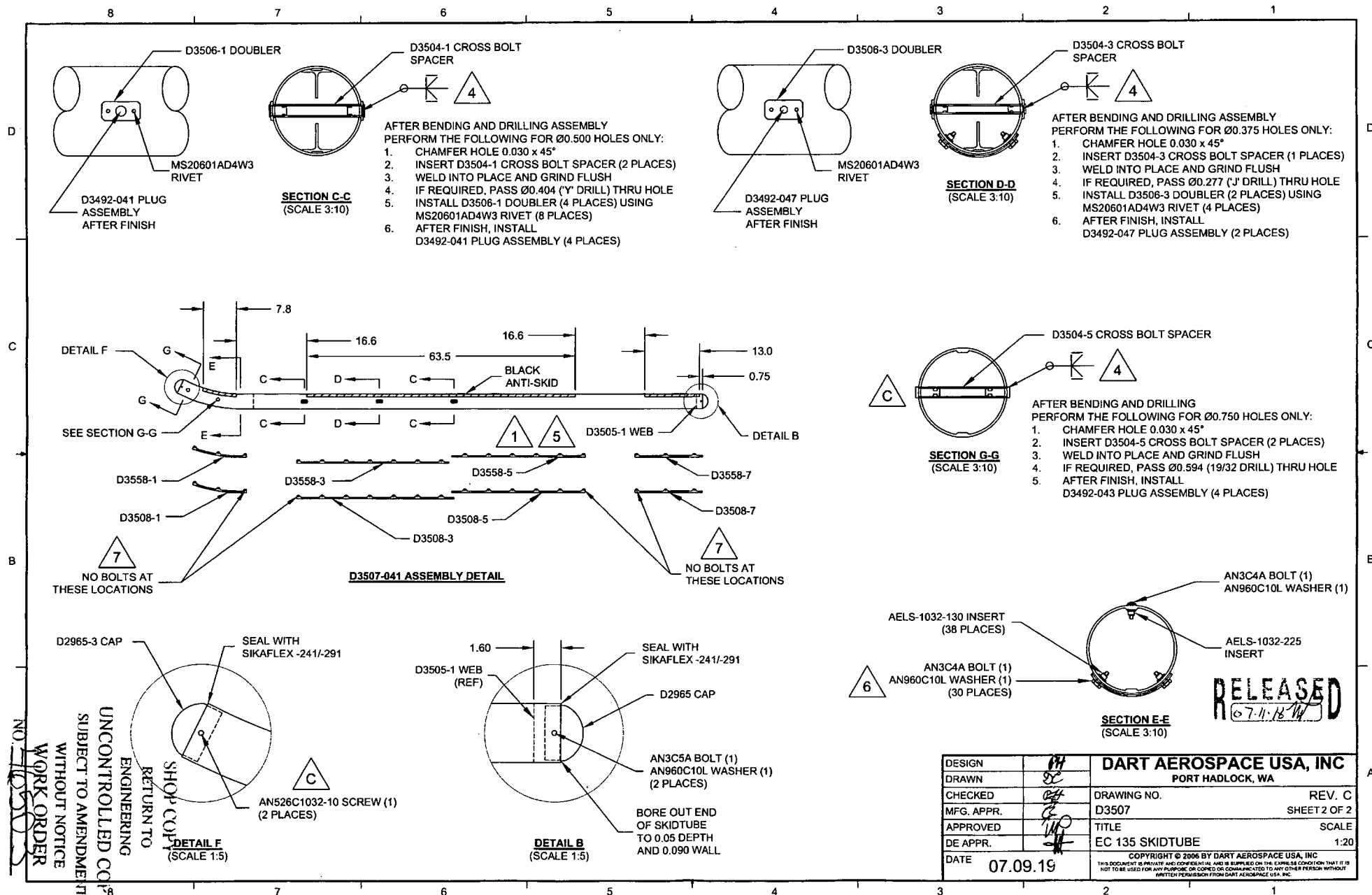
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D3507	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	1:2
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 179

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B41333
Part number: A135751011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David L. Lipp Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld